

## Work Order ID 115505

**\*115505\***

Page 1

April-02-14 11:14:15 AM

Item ID: D3391-023

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Mid Tube Assembly

Stop

**\*NS2\***

Start Date: 4/02/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 14-04-02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

**\*100\***

Skidtubes

Memo

0.00

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

3-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

4-Remove .030" from Fwd indexing Ridge as per Dwg D3391

5-Remove indexing ridge on Fwd &amp; Aft end of skidtube as per Dwg D3391

6-Deburr

7-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

\*\*\*DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG

8-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391

9-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

\*\*\*DO NOT OPEN 2 MOST FWD WEARPLATE HOLES\*\*\*

8E14-06-25

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Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*

874-06-25

11-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

12- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allignment, open up previously transfer drilled pilot holes in D3391-023-021 to 0.438" dia. in D3391-021  
D3391-021 BATCH: 115499

13- Using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

14- Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937

15- Open 10 wearplate holes in D3391-021 to 0.297" dia.

16- insert D3391-021 into D3391-23

17- insert T-pins into first and third fwd saddle holes

18- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ;

19- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".

20-Deburr and blow out all chips from inside tube, scribe batch # in D3391-023 at aft end.

DP 14-8-7

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\*NS2\*

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\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

Silvado

\*110\*

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

1 7/14-8-12

\*120\*

HandFinish

Memo

0.00

Hand Finishing

130

QC7-Inspect Chemical Conversion Coat

0.00

14-8-12

\*130\*

QC

Memo

0.00

Quality Control

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Item ID: D3391-023

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Item Name: Mid Tube Assembly

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**\*1\***

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

**\*140\***

Skidtubes

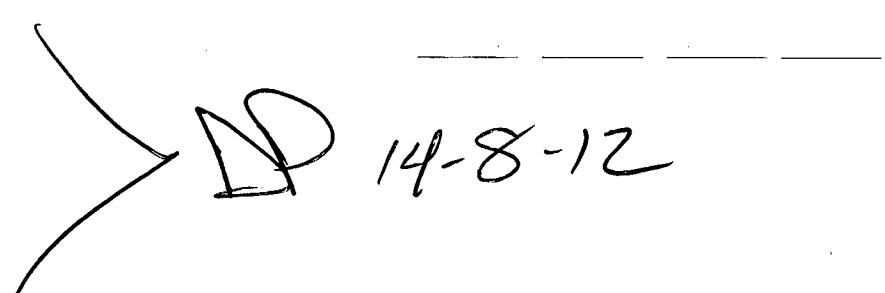
Skidtubes

0.00

0.00

Memo

1-Open float bag holes as per dwg  
2-C'sink float bag holes as per dwg  
3- Prepare tube for welding  
4-Bond.web in place as per Dwg D3391 & QSI 015.  
Adhere for 12 hours)  
A/R Sikaflex exp: 14-11-20  
batch#: M129457  
NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE



150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Quality Control

Memo

0.00

DAS  
18  
9-89

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Item ID: D3391-023

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\*NS1\*

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Item Name: Mid Tube Assembly

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\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

\*160\*

Skidtubes

Memo

0.00

\_\_\_\_\_

170

\*170\*

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

16

99

14608115

\_\_\_\_\_

180

\*180\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS

16

9-89

14608119

\_\_\_\_\_

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Item ID: D3391-023

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Mid Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

185

Pressure Wash per QSI005 4.3

0.00

1 764438

\*185\*

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1128959

Memo

0.00

START TIME: 2:00

OVEN TEMPERATURE: 320

FINISH TIME: 2:00

1 64499 DAS 34 9-89

\*190\*

Powdercoat

Powder Coating

200

QC3- Inspect Part Finish

0.00

1 64499 DAS 15 9-89

\*200\*

QC

Quality Control

Memo

0.00

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Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Mid Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

\*230\*

HandFinish

HandFinishing

0.00

1x 4 all check 16

Memo

0.00

Hand Finishing

1- press fit D3591-1 spacers using DT9416 starting from 0.500" side

2-Install Inserts as per Dwg

240

\*240\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

1 Spur  
W/9/17

250

\*250\*

Packaging

Packaging

Identify as per dwg & Stock Location: w/o

0.00

D412-742-043/B115492

1x 4 all w/o 4/16/16

Memo

0.00

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**Item ID:** D3391-023

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**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Mid Tube Assembly

Stop

**\*NS2\***

**Start Date:** 4/02/14    **Start Qty:** 1.00

**\*1\***

**Cust Item ID:**

**Required Date:** 4/16/14    **Req'd Qty:** 1.00

**\*1\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run

Start

**\*NR1\***

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

260

QC21- Final Inspection - Work Order Release

0.00

**\*260\***

QC

Quality Control

14/9/17 JH

**Memo**

0.00

J 14-a-17

## Picklist Print

April-02-14 11:14:18 AM

Page 1

**Work Order ID:** 115505

\*115505\*

\*D3391-023\*

**Parent Item:** D3391-023

**Parent Item Name:** Mid Tube Assembly

**Start Date:** 4/02/14

**Required Date:** 4/16/14

**Start Qty:** 1.00

**Required Qty:** 1.00

**Comments:** IPP A05.10.20 New Issue KJ/EC  
IPP B06.02.10 ECN773 dwg rev.D EC  
IPP C 07.03.20 rev F dwg EC  
IPP D 07.03.28 re-format EC  
IPP E 07.10.31 ecn 1053P EC  
IPP Rev:F ECN 1056 07-11-13 DD verified by: EC  
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC  
IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP  
Rev:J add in seq 140 expire date &# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-1-100

\*D2500-1-100\*

### Skidtube Extrusion

\* \* \*

8Enf-06-25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	83	
82373	22	
86065	61	
	140	Each
		8.0000
		1
		1

D3389-1

\*D3389-1\*

- Web

\*\*

17-8-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	8	
113057	8	
(14969	160	Each 234.0000 5 1 5

D3681-1

\*D3681-1\*

## Spacer

2

3E14'08-13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	168	
LG001	168	5
109109	66	

# Picklist Print

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Work Order ID: 115505

\*115505\*

Parent Item: D3391-023

\*D3391-023\*

Parent Item Name: Mid Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

D3591-1

Manufactured No

Each 88.0000

2

\*\*

M local 14

\*D3591-1\*

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	3115533
92873	10	
FP001	78	
100699	5	
107918	36	
109107	37	

ALS4-1032-130

AELS4-1032-130 Purchased

No

230 Each 9,937.000

20

20

\*\*

M local 14

\*A1 S4-1032-130\*

Rivnut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	9832	
M128649	9832	
ST279	48	
M128211	48	
st510	57	
M126109	57	

